

SOUTH PRODUCTION NOTES

**June 6, 2014
Day Shift**

**BASF EMPLOYEES
91 Last Recordable
341 Last Lost Time**

#1 MED / ICL-8:

Keep in contact with Kristen as we do not want to get too far ahead of the calciner. Keep a close eye on diameters. Anything from .129" to .133" is ok but anything higher than .133" will prompt a die change on the extruder. Check the oil in reservoir.

Midnight shift: Attempted to run a batch and valve still leaks. Further adjustment needed in the morning. Will extrude batch and leave it down.

Day shift: Valve was adjusted and we began making batches. Keep in contact with Kristen as we do not want to get too far ahead of the calciner.

Afternoon shift:

#1 RC / ICL-8:

Watch each drum for discoloration (tan) and isolate any of these drums for re feeding. If drum material looks all white, apply label and close. If material is tan, place label on top of drum for refeeding (tape it so it does not get lost).

Feed rate 400-425. We will feed the refire drums at a reduced temp (drop to 760 degrees) if needed.

Midnight shift: Hold...no material to feed

Day shift: Began feeding underfired drums. When these are done we need to raise the temperatures back to 490 and feed the material that is in bags coming off of the MED. Keep the feed rate below 425 to avoid creating more drums that need to be refired.

Afternoon Shift:

Exhaust to F1 for ICL-8

#2 MED line/ Cu-0860:

We will need to pull auger #13(tag on Mike's desk), clean it and return it to Calvin. Down until we get more 3818. Use the wet mix cart for cleaning out the barrel and add it back into the mixer. Do not over use the ice. One shovel full is plenty.

Midnight shift:

Day Shift: Decision made by the engineer late in the shift to change out the auger and the fines screen from an eleven mesh to a 10 mesh while we are down waiting for more 3818.

Afternoon Shift:

#2 RC/ Cu-0860:

Continue per the MOD. **Keep the feed rate up on this calciner. It has been too low lately.** Need the feed rate at 300 lbs / hr.

Midnight Shift:

Day shift: Continued to feed.

Afternoon shift:

Exhaust to F1

#3 MED line / D-0713:

MED is about ready. Powder room scale issues resolve with OCS work performed on Thursday afternoon. Be sure to use the cart for wet mix and add it into the mixer. Do not use drums unless a bad batch needs to be drummed off.

Midnight Shift:

Day shift: Pulva chain being installed late on 1st shift. Should be able to start after this is done.

Afternoon Shift:

#3 RC / D 0713 next:

All material fed, calciner coming down for reversing and cleaning for D 0713

Midnight shift: Initially running al/ox sand through calciner.

Day shift: Flush was finished . We will need to get this calciner set up as we do not want to get too far ahead of the calciner on the MED line.

Afternoon Shift:

Exhaust to Trimer

#4 RC / Cu 0360:

Hoist on 5RC has been replaced and we have re-started feeding. All three remaining bags of fresh feed have also been fed. At end of run maintenance needs to take a look at the spiral elevator – it has become very loud with an exaggerated up and down motion (#934196920).

Midnight Shift: Have fed all of the fresh material. Will start reducing temps on calciner.

Day shift: Feeding the last of the rescreen bags. Just have what is left in the hopper.

Afternoon Shift:

Exhaust to 4A DC

#5 RC / Cu-3818:

We will only use Phibrotech copper and the material will be discharged onto a 120 bag. Feed rate is at 14.0 hz.
Midnight shift: Continued to run.
Day shift: Continued to run.
Afternoon shift:

Exhaust to 5A DC

Old Pfaudler – D-0754:

In addition to the drainage sample we were collecting we must also collect a sample of each batch (8 oz baggy) and a sample of the solution tank. Make sure that all samples are properly labeled. Send to the lab for evaluation – this is a customer request let's make it happen with EVERY batch we make. Make sure that we add on the batch sheet any drainage collected and add to the label of the sample the batch number.

Midnight Shift: Continue.

Day Shift: No batch made(backed up).

Afternoon Shift:

#6 RC / D-0754:

Remember that we are to take a single large sample (not two, just one) per MOD and we need to collect a chemi sample that will be collected only during midnight shift. When running, be sure to:

(1) Get pallet and empty bag weight, write with marker on side of pallet and on check-weigh sheet. On pallet mark it "Tare *** lbs; (2) Fill bag, record net weight on sheet and add to tare weight; (3) Take full bag and pallet to check scale and re-weigh. Record check-weight on sheet and record difference on sheet.

Midnight shift: Continue feeding. Watch for material backing up on dryer.

Day Shift: Calciner relit with the help of an electrician. Feed was restarted in the early afternoon.

Afternoon shift:

Exhaust to Sly Scrubber

PK Blender / Na Selexorb Intermediate next:

Waiting for maintenance. Building, day tank and PK have been rinsed. Work order written to have the PK gear break looked at before end seals can be replaced(blender swings freely and does not stop quickly enough to control)(6/5/14 M.V.).

Midnight Shift: DOWN/Work order is in for end seal.

Day shift: Work order written to have the PK gear break looked at before end seals can be replaced(blender swings freely and does not stop quickly enough to control).

Afternoon shift:

New Pfaudler / Cu 0226-start on Next Tuesday :

Need cleaning instructions

Midnight shift: No activity

Day shift:

Afternoon Shift: No activity.

Abbe Blender – D-5206:

We can run on the weekend and off shifts. 20 more bags of raws are due in Friday.

Midnight shift: No activity as last batches made afternoon shift

Day shift: No change. 20 more bags of raws are due in Today.

Afternoon Shift:

National Dryer / D-5206:

Feed as material becomes available.

Midnight Shift: Feeding as material available

Day shift: No change.

Afternoon Shift:.

Tower 3 /Cu-0860 is Next:

Loaded. Started running. Sheaves have been changed

Midnight Shift:

Day shift: Loaded and running. Another couple of days.

Afternoon shift:

Tower 6 / 930 VAM:

Loaded and running. Each tower load will take 5 super sacks filled with 8 drums.

Midnight Shift:

Day shift: Loaded and cooking. Will need to be unloaded 1st thing on 2nd shift.

Afternoon shift: Running.

North Screener / DPT-101:

We need to double band all of the socks to the bins BEFORE OPENING ANY BINS – use the newly acquired adjustable quick disconnect hose clamps. Make sure that we hit the MOD rate.

Midnight shift: Setting up to screen as tower was unloaded

Day shift: Continued to screen.

Afternoon Shift:

South Screener / Change over to Cu-0860:

We need to double band all of the socks to the bins BEFORE OPENING ANY BINS – we have now in place the newly acquired adjustable quick disconnect hose clamps. Make sure that we hit the rate required.

Midnight shift: Changed over to Cu-0860

Day shift: On hold for first load of Cu-0860.

Afternoon Shift:

Harrop Kiln

Need to load AL saggars that are clean.

#2662 (east) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.

Midnight shift: No change

Day Shift: No change

Afternoon shift: No change

#2664 (west) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.

Midnight shift: No change

Day Shift: No change

Afternoon shift: No change

TK #2 Change over to V 2010:

We can use V 2010, AL saggars that are clean, or new saggars.

Midnight shift:

Day Shift: Kiln was shutdown. Ok was given late in the shift to begin changing over saggars for v 2010.

Afternoon shift:

At screeners: all totes need to have two bands fastened to sock before opening a new tote.

Work notification to place duct work hangers on the second floor (bldg. 31) – 934147915.
Work notification written to cap / remove ductwork around #3 mixer – 934147916.
Work order to repair hoist for 5 feed hopper.

1. Fines need to be recorded daily on the green sheet.